

FIG. 1

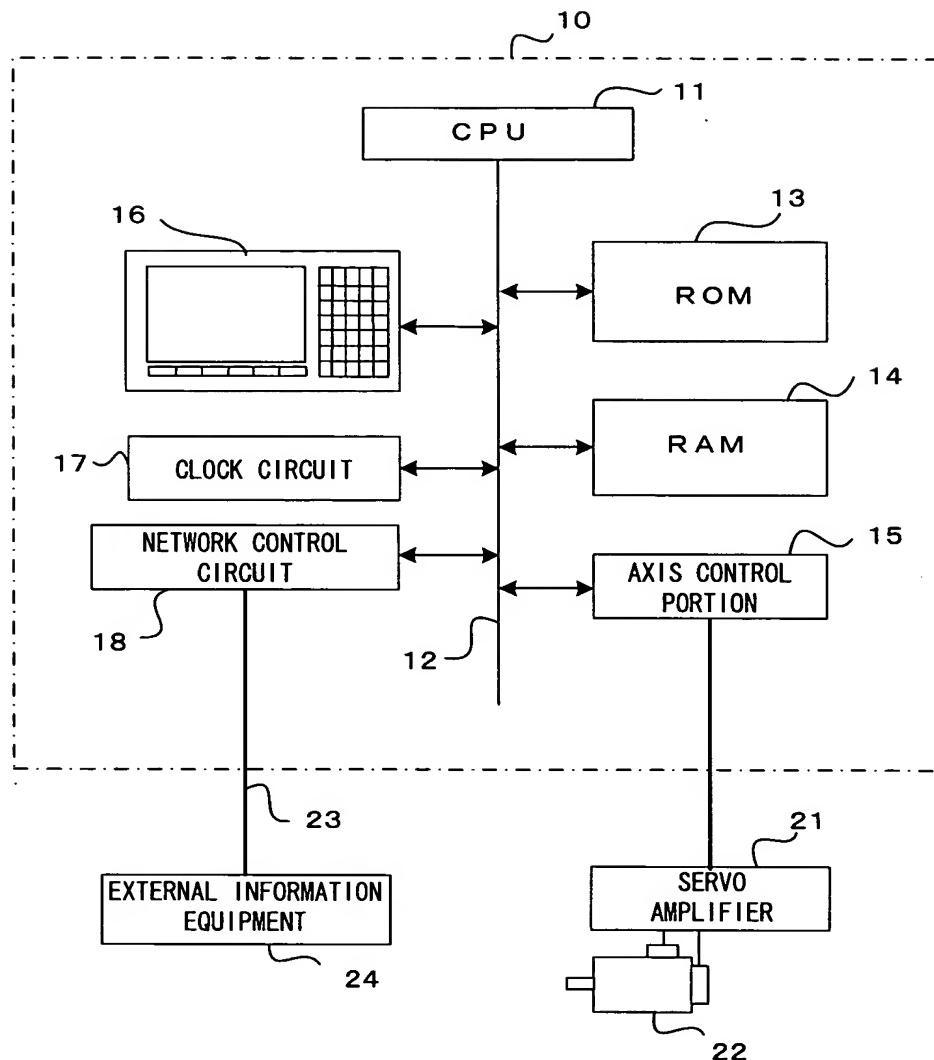


FIG. 2

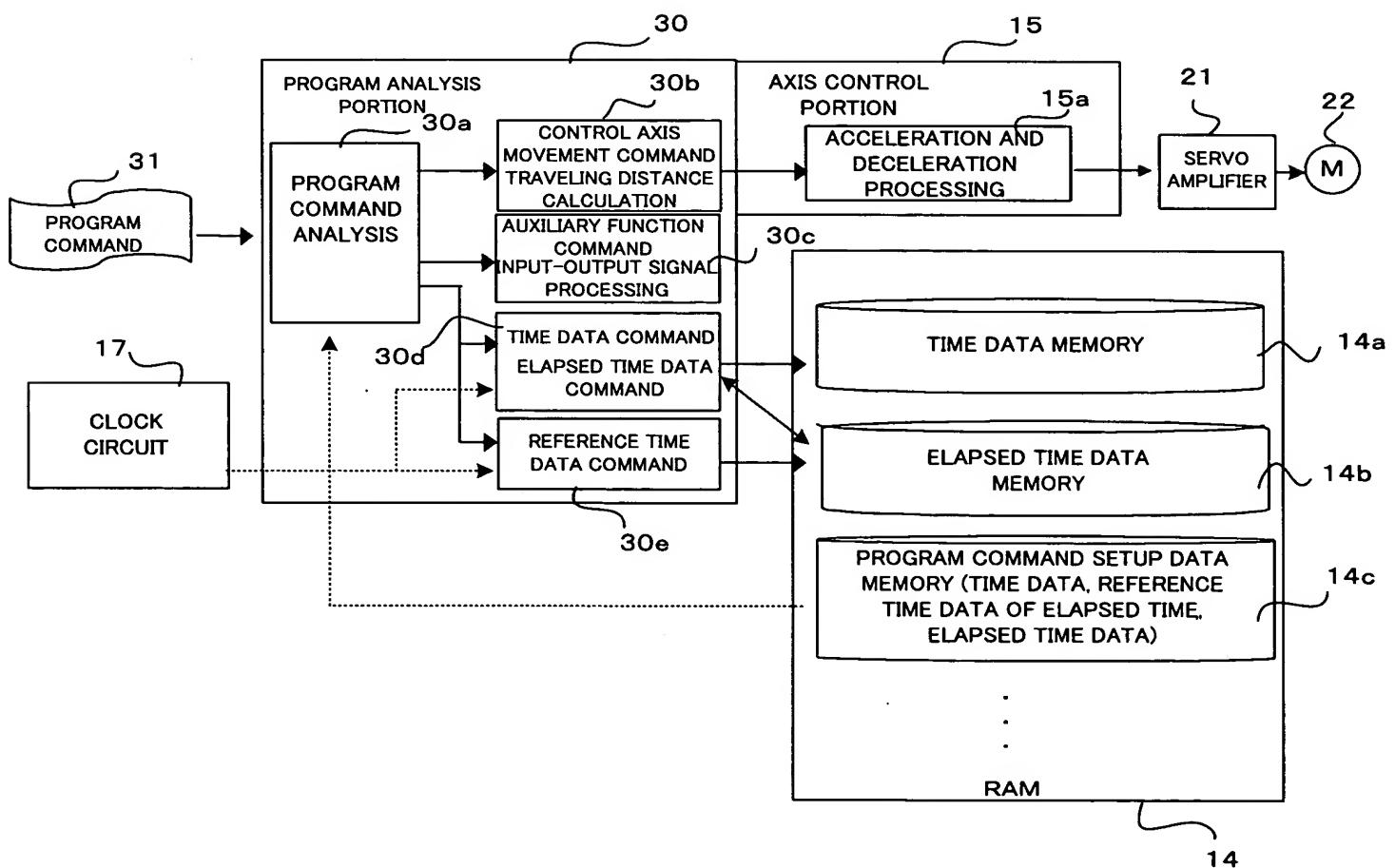


FIG. 3

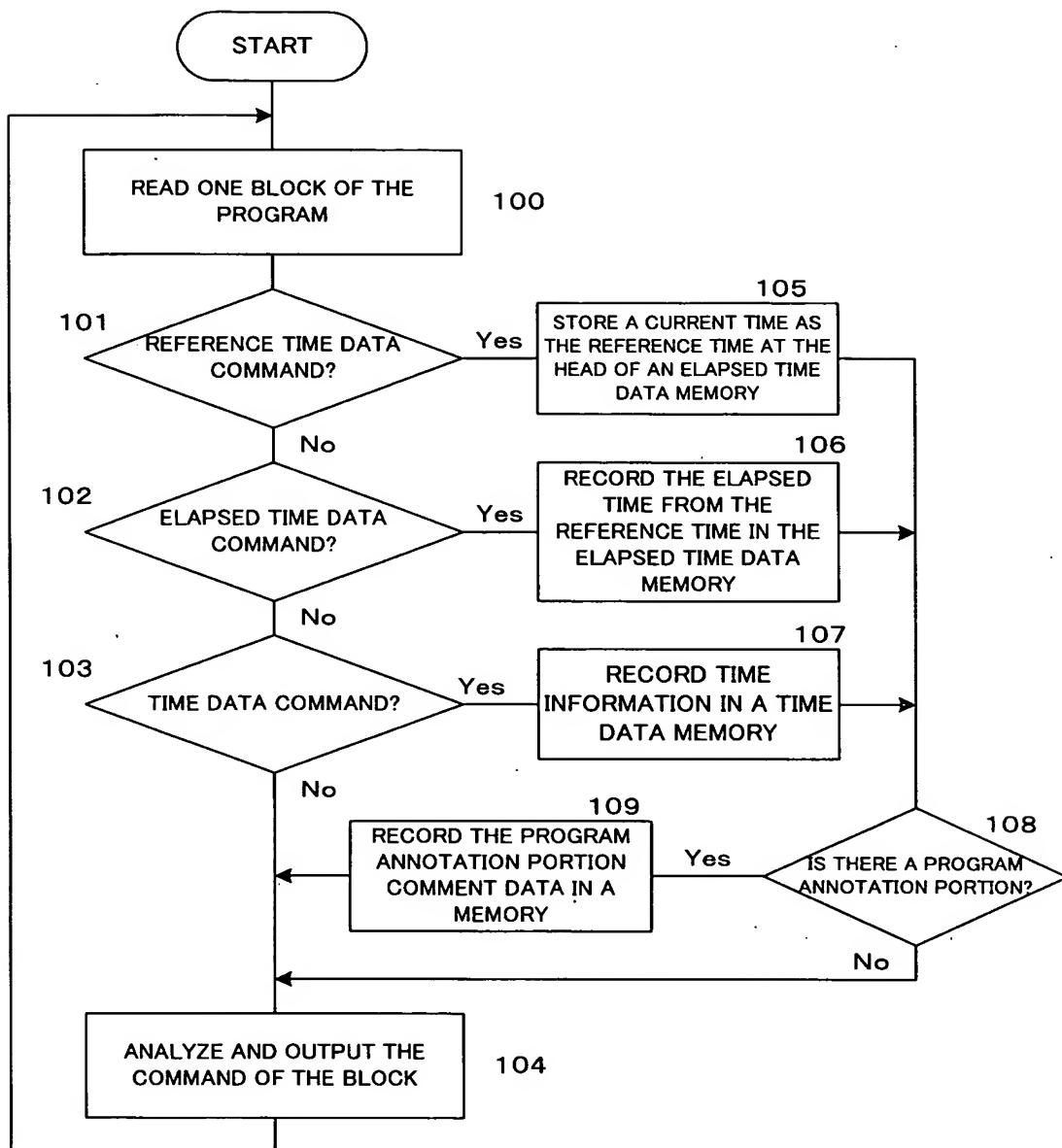


FIG. 4

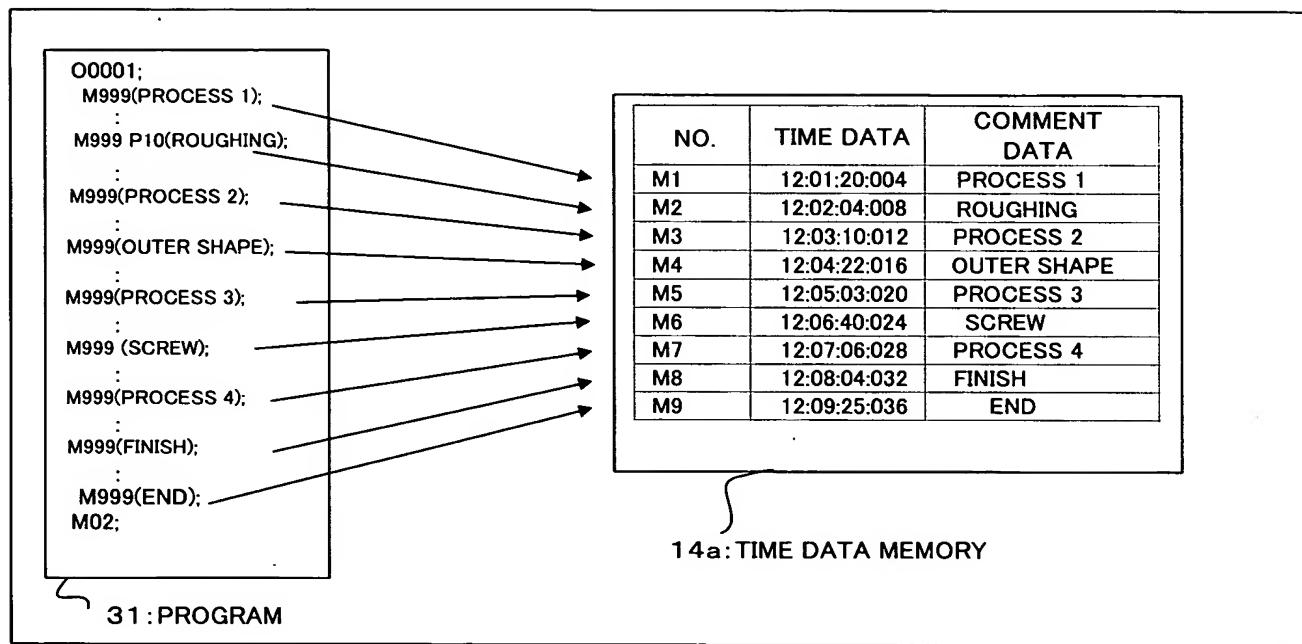


FIG. 5

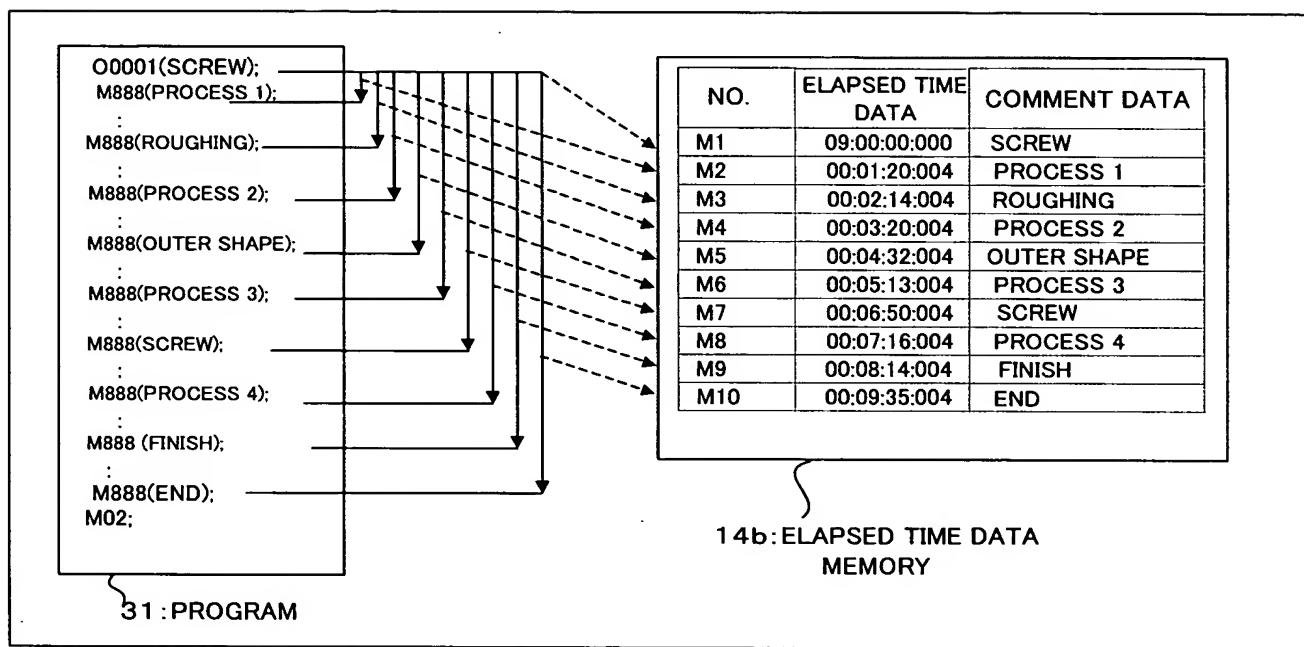


FIG. 6

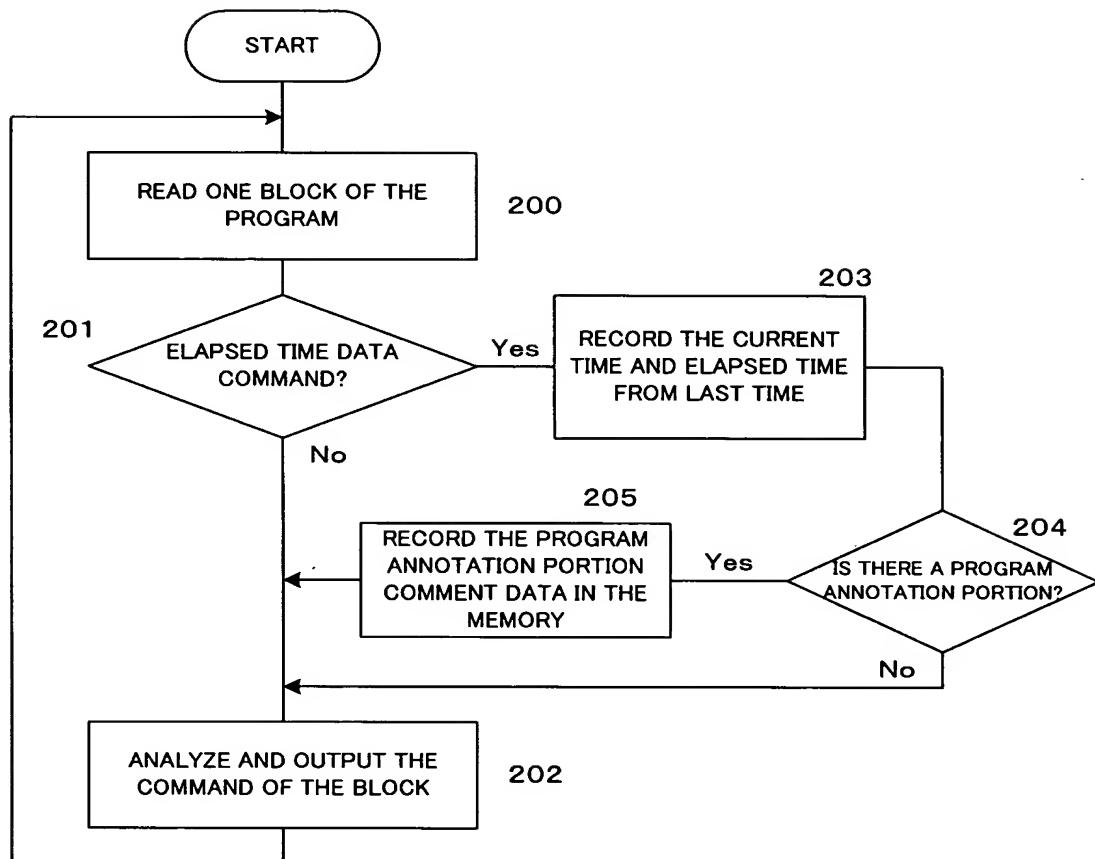


FIG. 7

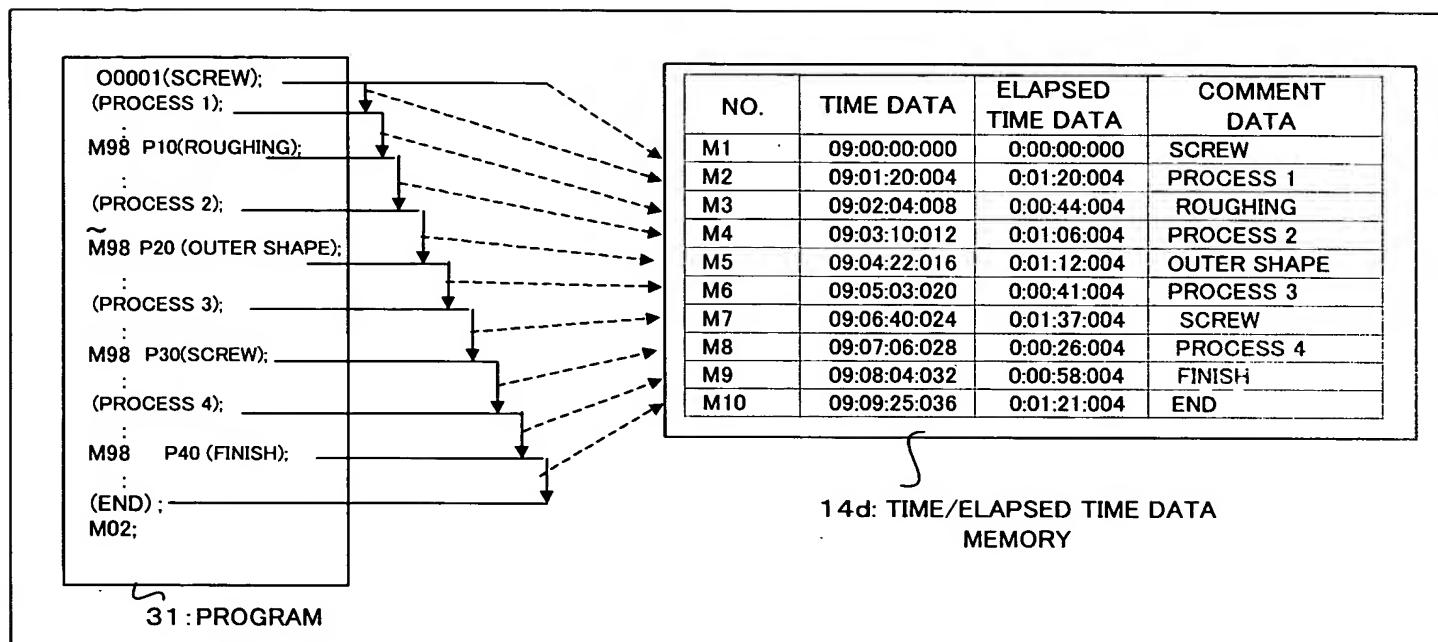


FIG. 8

TIME DATA	COMMENT DATA
0:00:00:000	SCREW
0:01:20:004	PROCESS 1
0:00:44:004	ROUGHING
0:01:06:004	PROCESS 2
0:01:12:004	OUTER SHAPE
0:00:41:004	PROCESS 3
0:01:37:004	SCREW
0:00:26:004	PROCESS 4
0:00:58:004	FINISH
0:01:21:004	END

NO	TIME DATA	ELAPSED TIME DATA	COMMENT DATA
M1	09:00:00:000	0:00:00:000	SCREW
M2	09:01:20:004	0:01:20:004	PROCESS 1
M3	09:02:04:008	0:00:44:004	ROUGHING
M4	09:03:10:012	0:01:06:004	PROCESS 2
M5	09:04:22:016	0:01:12:004	OUTER SHAPE
M6	09:05:03:020	0:00:41:004	PROCESS 3
M7	09:06:40:024	0:01:37:004	SCREW
M8	09:07:06:028	0:00:26:004	PROCESS 4
M9	09:08:04:032	0:00:58:004	FINISH
M10	09:09:25:036	0:01:21:004	END

14d: TIME/ELAPSED DATA MEMORY

TIME DATA DISPLAY
SCREEN